



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D3574-2
Job Sheet 182241



Part No: D3574-2

Job Qty: 1 ea

Part Name: Cabin Floor Protector



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 8/21/18

Job Tracking No:

Due Date: 9/7/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV B IPP Rev :A New Issue 07-01-22 EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	9/7/18	9/7/18	0.00	0.00	Start Up Waterjet		SL 18/08/23
100	Waterjet	1 pcs	9/7/18	9/7/18	0.72	0.43	Waterjet1		SL 18/08/23
110	QC	1 pcs	9/7/18	9/7/18	0.00	0.00	QC2 Waterjet-2		SL 18/08/23
120	QC	1 pcs	9/7/18	9/7/18	0.00	0.00	QC8-3		AUG 24 2018 9-89
150	Packaging	1 pcs	9/7/18	9/7/18	0.00	0.00	Packaging3	pk602	AUG 27 2018 9-89
160	QC21-SA	1 Ea	9/7/18	9/7/18	0.00	0.00	QC21		AUG 28 2018 9-89

Part Op 100 - 1-Cut as per Dwg D3574 Dwg Rev: B Prog Rev: B 2-Deburr

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MLEXS.125-F60029-04	GE Plastics Lexan Sheet (Dark Grey)	21.5500 sf (21.55 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	MLEXS.125-F60029-04	22	2,631	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	Skid-tube ☐ Machining ☐ Thermoforming ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Cross tube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Cross tube ☐	Water Jet ☐	Engineering ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Composite ☐	Supplier ☐	
Cross tube ☐	Water Jet ☐	Engineering ☐													
Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐													
Finishing ☐	Rec/Store/Packaging ☐	Other ☐													
Composite ☐	Supplier ☐														
Date : _____		MRB (QSI042) Approval _____ position													
Dart Aerospace Ltd. 1270 Aberdeen Street Hewitson, ON T6A 1K7 CANADA TEL.: 1 813 832-8200 Email: sales@dartaero.com www.dartaerospace.com Date: 08/24/18 Container No: S104756 Part: D3574-2 Job No: 182241 Serial No/Batch: S104756 Revision: _____ Inspector: _____ Exp Date: _____ Instructions: Various STC's Date: 08/24/18															

DART AEROSPACE LTD		Work Order:	182241
Description: Cabin Floor Protector		Part Number:	D3574-2
Inspection Dwg: D3574	Rev: B	Page 1 of 2	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø3.00	+0.006/-0.001	Ø3.00				
7.37	+/-0.030	7.37				
10.75	+/-0.030	10.75				
11.00	+/-0.030	11.00				
15.25	+/-0.030	15.25				
25.87	+/-0.030	25.87				
39.75	+/-0.030	39.75				
44.75	+/-0.030	44.75				
53.51	+/-0.030	53.51				
63.50	+/-0.030	63.50				
65.25	+/-0.030	65.25				
10.75	+/-0.030	10.75				
11.00	+/-0.030	11.00				
14.75	+/-0.030	14.75				
25.50	+/-0.030	25.50				
25.75	+/-0.030	25.75				
26.00	+/-0.030	26.00				
32.87	+/-0.030	32.87				
38.81	+/-0.030	38.81				
45.00	+/-0.030	45.00				
48.25	+/-0.030	48.25				
58.38	+/-0.030	58.38				
61.25	+/-0.030	61.25				
64.13	+/-0.030	64.13				
64.63	+/-0.030	64.63				
66.50	+/-0.030	66.50				
7.50	+/-0.030	7.50				
9.50	+/-0.030	9.50				
10.38	+/-0.030	10.38				
10.88	+/-0.030	10.88				
14.50	+/-0.030	14.50				
16.56	+/-0.030	16.56				
18.75	+/-0.030	18.75				
24.13	+/-0.030	24.13				

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

DART AEROSPACE LTD		Work Order:	182241
Description: Cabin Floor Protector		Part Number:	D3574-2
Inspection Dwg: D3574 Rev: B		Page 2 of 2	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
26.50	+/-0.030	26.50			VSC-01	
30.50	+/-0.030	30.50			T922	
33.88	+/-0.030	33.88				
39.50	+/-0.030	39.50				
40.25	+/-0.030	40.25				
43.50	+/-0.030	43.50				
46.60	+/-0.030	46.60				
7.63	+/-0.030	7.63				
11.00	+/-0.030	11.00				
11.50	+/-0.030	11.50				
16.75	+/-0.030	16.75				
19.00	+/-0.030	19.00				
22.50	+/-0.030	22.50				
30.75	+/-0.030	30.75				
32.63	+/-0.030	32.63				
32.75	+/-0.030	32.75				
35.13	+/-0.030	35.13				
36.50	+/-0.030	36.50				
40.00	+/-0.030	40.00				
41.88	+/-0.030	41.88				
43.63	+/-0.030	43.63				
0.125	+/-0.010	0.125				

Measured by:	SC	Audited by:		Prototype Approval:	N/A
Date:	18/08/23	Date:		Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.02.28	New Issue	KJ/DD	
B	08.07.31	47.75 dimension removed	KJ/DD	
C	09.05.15	Dimensions updated per Dwg Rev B	KJ	

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Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
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Past Expiry Date ☐	Manufacturing Process ☐	OTHER :							
Misidentified ☐	Past Due ☐								